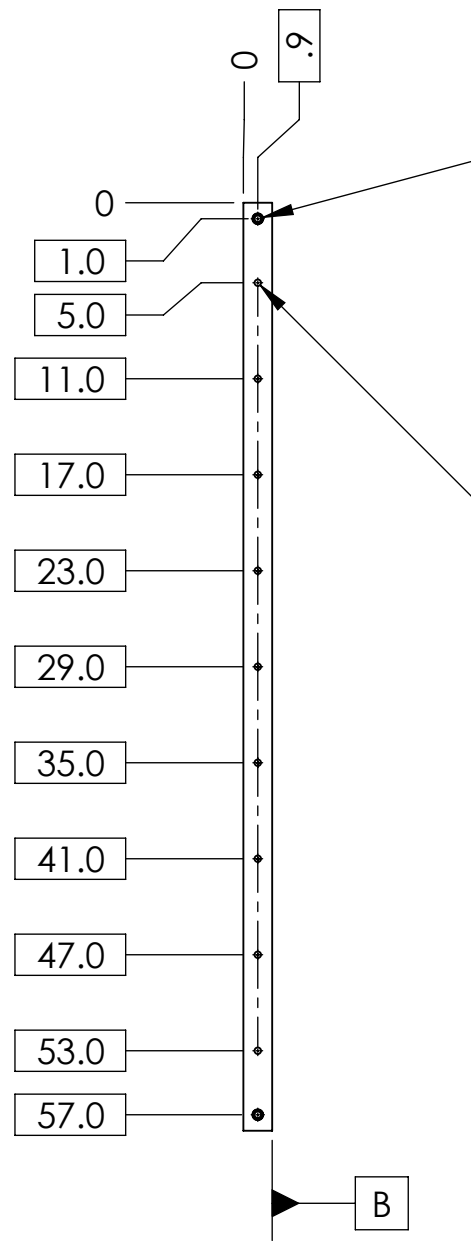


D1200530 Riser for HAM1-H1 ISI at LIGO, PART PDM REV: X-000, DRAWING PDM REV: X-001

NOTES CONTINUED:

5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

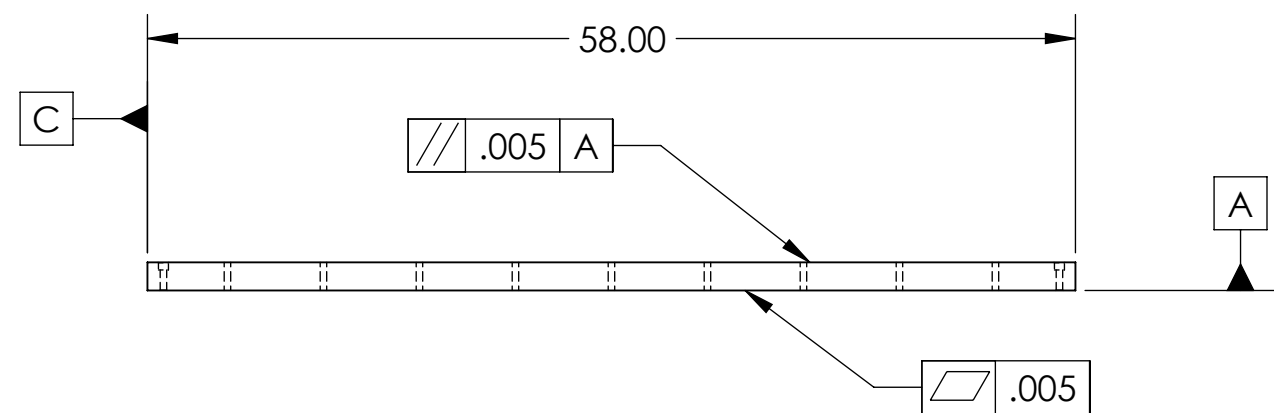
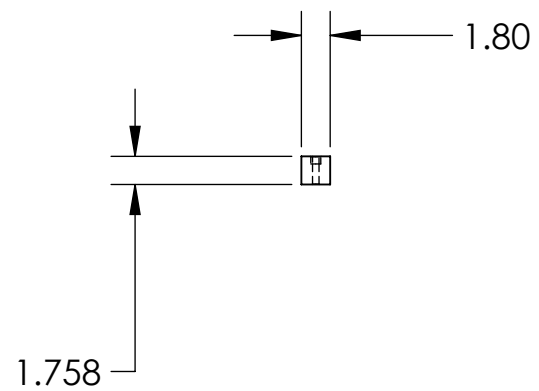
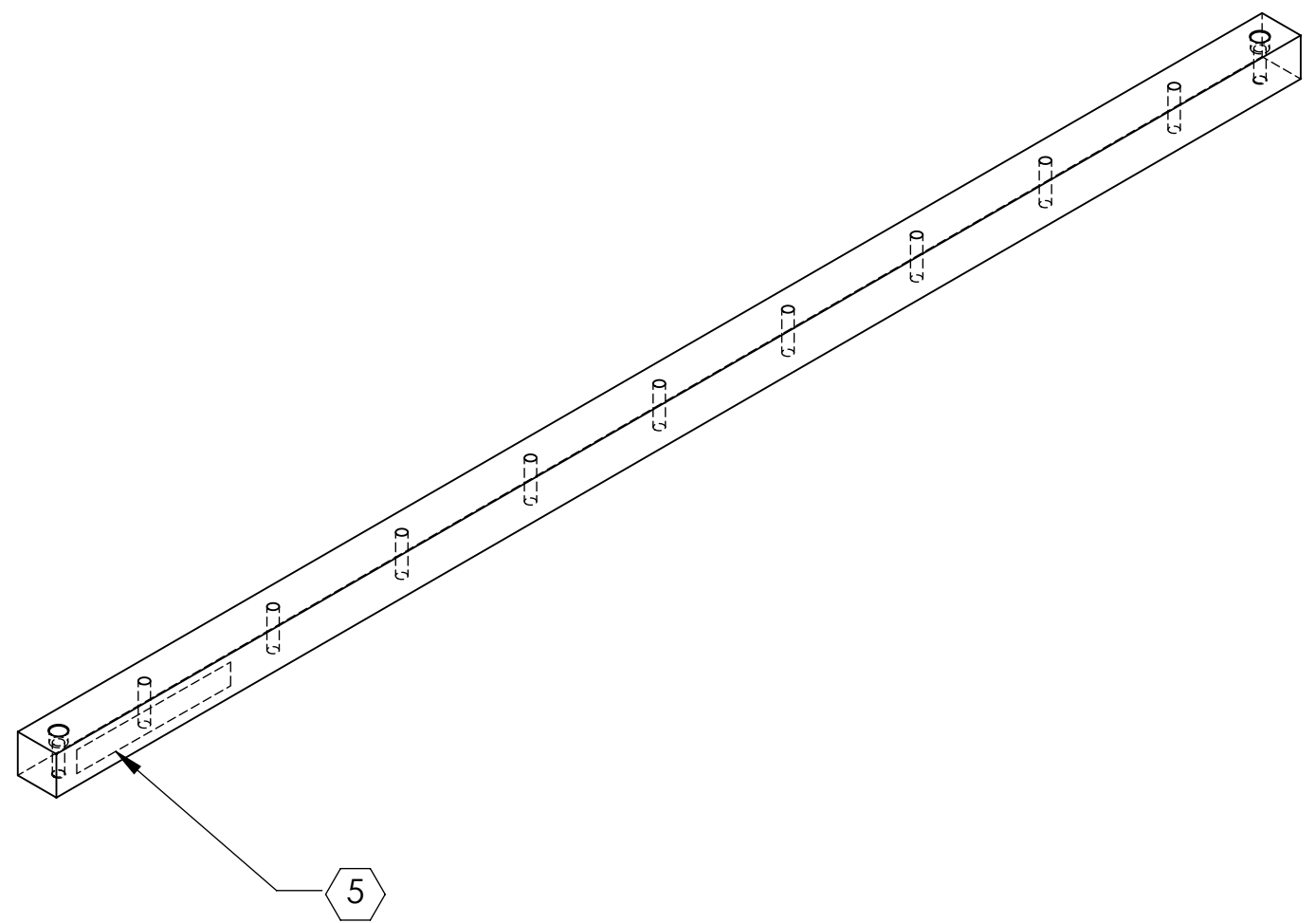
REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



2X ϕ .406 THRU ALL
 \square ϕ .625 ∇ .48
 \sphericalangle ϕ .68 X 90°, NEAR SIDE
 \sphericalangle ϕ .46 X 90°, FAR SIDE

\oplus .010 A B C

9X ϕ .406 THRU ALL
 \oplus .010 A B C



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX \pm .02 .XXX \pm .005 ANGULAR \pm 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM HAM ISI		SUB-SYSTEM SEI		DESIGNER SBARNUM 28 Mar 2012		SIZE DWG. NO. B D1200530		REV. v1	
						MATERIAL 6061 Alloy		FINISH 63 μ inch		NEXT ASSY D0901821		CHECKER APPROVAL		SCALE: 1:12 PROJECTION:	